Work Order ID 95673

Wednesday, January 16, 2013 12:57:05 PM

95673

Item ID:	D2369-3	Accept	***N9000401 00***	Setup Start ***NS1***
Revision ID:				Stop ***NS2***
Item Name:	Deck Plate Locator Brackets			

Start Date:	1/16/2013	**Start Qty:** 16.00	***16***	**Cust Item ID:**	
Required Date: 1/31/2013		**Req'd Qty:** 16.00	***16***	**Customer:**	
Reference:					

Approvals:	**Process Plan:** *JMF*	Date 3-0t-0/	**Tooling:**	Date:	Run Start ***NR1***
	QC:	Date:	**SPC (Y/N):**	Date:	Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2369	Rev A								
100 ***100*** Waterjet FLOW CNC Waterjet 5052 .040	FLOW WATER JET Memo Prg: Rev A Dwg: Rev A	0.00 0.00				16	0		Jm 13-2-1
110 ***110*** QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				16	0		Jm 13-2-1
120 ***120*** QC Quality Control	QC8- Inspect parts - second check Memo	0.00 SmB 0.00 13-2-4				16			

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

	DISPOSITION	AGAINST DEPARTMENT/PROCESS
Work Order: _____ Part No. _____ NCR No. _____	Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	_____	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	_____	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions	_____	

Work Order ID   95673

Wednesday, January 16, 2013 12:57:05 PM

95673

Item ID:	D2369-3	Accept	***N9000401 00***
Revision ID:			
Item Name:	Deck Plate Locator Brackets		

Start Date:	1/16/2013	**Start Qty:** 16.00	***16***	**Cust Item ID:**
Required Date:	1/31/2013	**Req'd Qty:** 16.00	***16***	**Customer:**
Reference:				

Setup Start ***NS1***
Stop ***NS2***

Approvals: **Process Plan:** MF   **Date:** 13-1-16   **Tooling:**   **Date:**
QC: **Date:**   **SPC (Y/N):**   **Date:**

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Deburr								
	NA SN								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location:	0.00							
150	24/A								
Packaging	Memo	0.00							
Packaging									

13/07/4 (16)

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**
	Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐ Equip/Tooling ☐ Operator ☐ Material ☐ Setup ☐ Other ☐ Process ☐ Supplier ☐ Training ☐ Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration		_____
☐ Turning Sequence	☐ Finish	☐ Out of Sequence		_____
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		_____

Item ID:	D2369-3			Accept	*N9000401nn*	Setup	Start	*NS1*

Revision ID:

Item Name: Deck Plate Locator Brackets

Stop *NS2*

Start Date:	1/16/2013	Start Qty:	16.00	*16*	Cust Item ID:
Required Date:	1/31/2013	Req'd Qty:	16.00	*16*	Customer:

Reference:

Approvals:	Process Plan:		Date:	Tooling:		Date:	Run	Start	*NR1*
	QC:		Date:	SPC (Y/N):		Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC21- Final Inspection - Work Order Release	0.00						13/2/5	
	Memo	0.00							

WORK ORDER NON-CONFORMANCE / UPDATE

NCR: Yes / No

QA Closed: _____ Date: _____

Work Order: _____	**DISPOSITION**		**AGAINST DEPARTMENT/PROCESS**				
Part No. _____	Rework ☐		Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐	
	Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
NCR No. _____	Work Order Update ☐		Large Fab ☐	Composite ☐	Supplier ☐		

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear

	General				
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	_____	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	_____	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions	_____	

Picklist Print

Work Order ID:	95673			
Parent Item:	D2369-3		Start Date: 1/16/2013	Required Date: 1/31/2013
Parent Item Name:	Deck Plate Locator Brackets		Start Qty: 16.00	Required Qty: 16.00

Comments:	IPP Rev A	Removed from 9 Digit 05-12-05 JLM
	IPP Rev:B	Now on Waterjet 07-05-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.040		Purchased	No			110	sf	79.0000	1.354	22.804211			
5052-H32 .040 Sheet										23			Jm3-Q-1

Location	Loc Qty	Loc Code
MAT022	79.000045	
122406	15.000045	
124445	64	124445

DART AEROSPACE LTD					Work Order:	9S673	
Description: Deck Plate Locator Bracket					Part Number:	D2369-3	
Inspection Dwg: D2369 Rev: A						Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

[X] **First Article**   [ ] **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/-0.010	0.504"	—		V	Jkmo1
4.500	+/-0.010	4.509'	—		N	
5.709	+/-0.010	5.706"	—		V	
Ø0.128	+0.005/-0.000	0.128"	—		V	
37.990	+/-0.010	37.990"	—		T	Jkmo6
38.297	+/-0.010	38.297"	—		T	
5.000	+/-0.010	5.006"	—		V	
4.490	+/-0.010	4.495"	—		V	
0.664	+/-0.010	0.669"	—		V	
39.000	+/-0.010	39.000"	—		T	
38.528	+/-0.010	38.528"	—		T	

Measured by:	Jm	Audited by:	SmP	Prototype Approval:	N/A
Date:	13-2-1	Date:	13-2-4	Date:	N/A

Rev	Date	Change		Revised by	Approved
A	04.06.25	New Issue	P/O D350-616-015	KJ/JLM	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**			
Part No. _____	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
NCR No. _____	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	_____	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	_____	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions	_____	

DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	B WILLIAMS	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D2369	SHEET 2 OF 2
DATE		TITLE	SCALE
95:02:20		DECK PLATE LOCATOR BRACKETS	1:7

DART

QA COPY ISSUED

RELEASED
96 06 10

45273

5.000
4.490
0.664

38.297
37.990

39.000
38.528

LABEL (D2344 UP)

FWD

ø0.128
(6 PLACES)

5.709

1.000

0.000

4.500

0.500
0.000
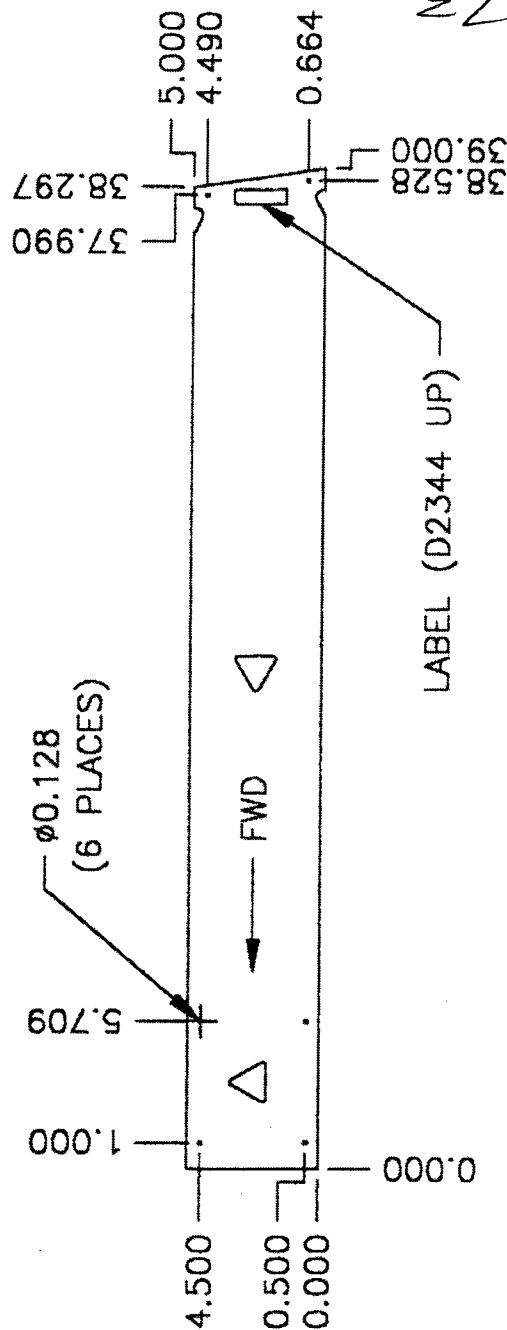
D2369-3

MATERIAL: 5052-H34 0.040 THICK

NCR: Yes / No

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____	**DISPOSITION**		**AGAINST DEPARTMENT/PROCESS**			
Part No. _____	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
NCR No. _____	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	_____	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	_____	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions	_____	